

Work Order ID 63710



November 10, 2010 11:48:51 AM

Item ID: D412-750-142

Accept



Setup Start



Revision ID:

Stop



Item Name: Tail Light Fairing, RH

Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

N/A

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-750-142 CHG001

Sorulu

CL 10-11-11

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/11/11 SLP

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

***** Ensure part is a R/H as per dwg *****

Sorulu

74 R/H

Work Order ID 63710

November 10, 2010 11:48:52 AM



Item ID: D412-750-142

Accept



Setup Start



Revision ID:

Stop



Item Name: Tail Light Fairing, RH

Start Date: 11/10/10 Start Qty: 4.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-750-142 Location: 22 PPP Rev: A

10/11/11 42

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/11 42
R 211-11
(4)

Picklist Print

November 10, 2010 11:48:51 AM

Page 1

Work Order ID: 63710

Parent Item: D412-750-142

Parent Item Name: Tail Light Fairing, RH

Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP revA 06.09.22 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-3A

Purchased

No

120

Each

159.0000

10

40

Bolt

Location

Loc Qty

Loc Code

ST350

159

~~113121~~

2

~~114615~~

1

~~115016~~

56

~~115621~~

100

AN960JD10

NAS1149D0363J

Purchased

No

120

Each

8.0000

10

40

Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

D3484-042

Manufactured

No

120

Each

8.0000

1

4

Tail Light Fairing Assembly, RH

Location

Loc Qty

Loc Code

ST205

8

52998

8

~~REFERENCE ONLY~~

- 3.8 Fasten the D3484-041/-042 Tail Light Fairing complete with A2064-1683 Tail Light Assembly to the tailboom using the provided (10) AN3-3A bolts into the tailboom's existing holes. Torque bolts 15-25 lb-in (1.7-2.8 N-m). Refer to Figure 1, Detail A.

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation of the D412-750-141/-142 Tail Light Fairing Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-750-141	0.13 lb	6.0 in	0.78 lb-in	296.1 in	38.49 lb-in
<i>Tail Light Fairing Kit, LH</i>	0.06 kg	0.2 m	0.01 kg-m	7.5 m	0.45 kg-m
D412-750-142	0.13 lb	6.0 in	0.78 lb-in	296.1 in	38.49 lb-in
<i>Tail Light Fairing Kit, RH</i>	0.06 kg	0.2 m	0.01 kg-m	7.5 m	0.45 kg-m

5.0 PARTS LIST

Qty – 141	Qty – 142	Part Number	Description
X		D412-750-141	TAIL LIGHT FAIRING KIT, LH
	X	D412-750-142	TAIL LIGHT FAIRING KIT, RH
1		D3484-041	TAIL LIGHT FAIRING ASS'Y, LH
	1	D3484-042	TAIL LIGHT FAIRING ASS'Y, RH
10	10	AN3-3A	BOLT
10	10	AN960JD10	WASHER

8

7

6

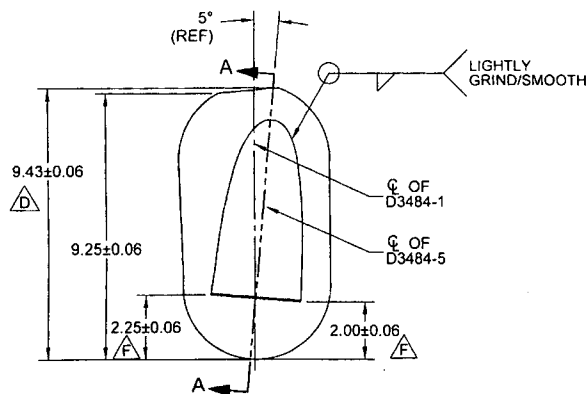
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4

3

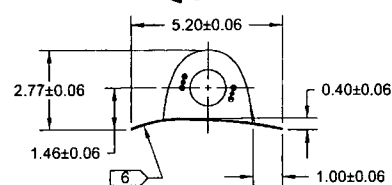
2

1



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
1		D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
1		D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
1		D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT

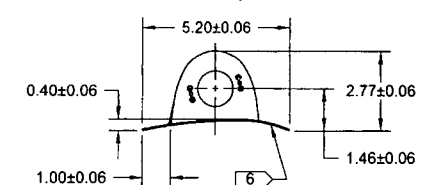
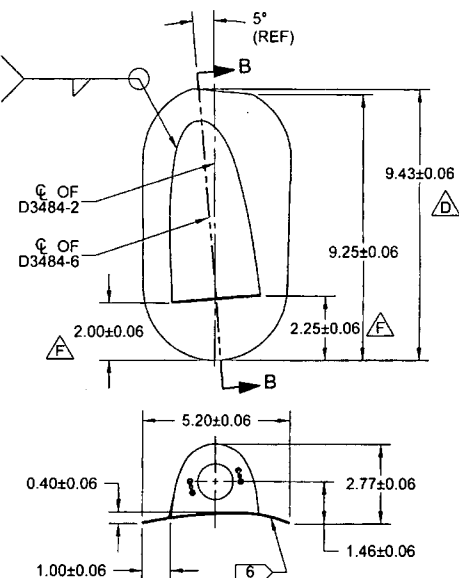
REFERENCE ONLY

INSTALL MS21069-04
ANCHOR NUT
(2 PLACES)

SECTION A-A

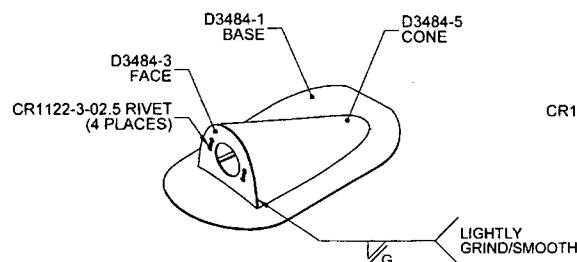
INSTALL MS21069-04
ANCHOR NUT
(2 PLACES)

SECTION B-B

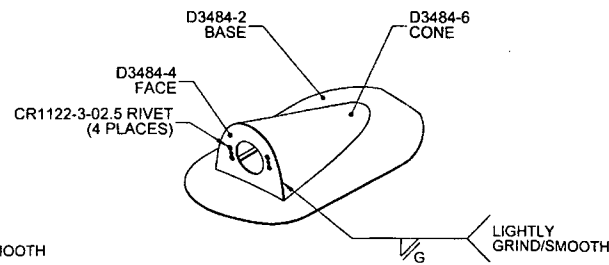


D3484-041 TAIL LIGHT FAIRING

D3484-042 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW





D3484-042 ISOMETRIC VIEW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) WELDING: PER DART QSI 004
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
- 7) WEIGHT: 0.30 lbs

RELEASED
09/03/31

F	UPDATE MATERIAL SPEC. ADD 6061-0, ZN A7-2, A7-3, B3-4. UPDATE DIMENSIONS ZN C1-1, C2-1, C7-1, C8-1 UPDATE WELDING NOTE ZN A3-1, A6-1		09.03.31
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY: CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/-5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.31	DRAWING NO. D3484	REV. F SHEET 1 OF 4
		TITLE TAIL LIGHT FAIRING	SCALE 1:4
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